

Work Order ID 66823

Monday, February 28, 2011 11:24:34 AM



Page 1

Item ID: D3536-37

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 2/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 11-02-28 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

MM NOT PULLED

B11-2-28

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-2-28

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/103/02

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 66823

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Page 2

Item ID: D3536-37

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Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 2/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: FA

0.00



Packaging

Memo

0.00

Packaging

11/3/25
122

140

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/04 dg

mr
11-03-02

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NOTE: Date & initial all entries

Picklist Print

Monday, February 28, 2011 11:24:40 AM

Page 1

Work Order ID: 66823

Parent Item: D3536-37

Parent Item Name: Gasket



Start Date: 2/28/2011

Required Date: 3/4/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	465.0000	0.7534	10.04533			
NEOPRENE SHEET 0.063													

1B1-2-28

Location

Loc Qty

Loc Code

MAT

465

115916

65

116832

400

116832

12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	66823
Description: Gasket		Part Number:	D3536-37
Inspection Dwg: D3536		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.190	✓		V 1302	
0.30	+/-0.030	.301	✓		V	
0.30	+/-0.030	.300	✓		V	
1.89	+/-0.030	1.886	✓		V	
6.00	+/-0.030	6.00	✓		T 1301	
8.00	+/-0.030	8.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
21.00	+/-0.030	21.00	✓		T	
2.00	+/-0.030	2.00	✓		T	
4.75	+/-0.030	4.75	✓		T	
9.50	+/-0.030	9.56	✓		T	
14.25	+/-0.030	14.25	✓		T	
17.75	+/-0.030	17.75	✓		T	
22.50	+/-0.030	22.50	✓		T	
27.25	+/-0.030	27.25	✓		T	
30.75	+/-0.030	30.75	✓		T	
0.063	+/-0.010	.057	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-2-28	Date: 11/03/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	AA

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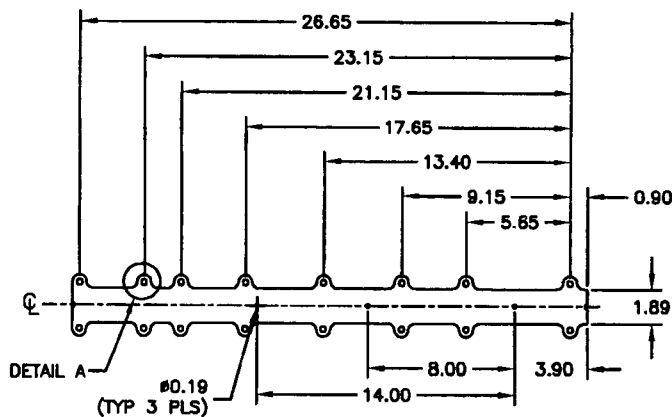
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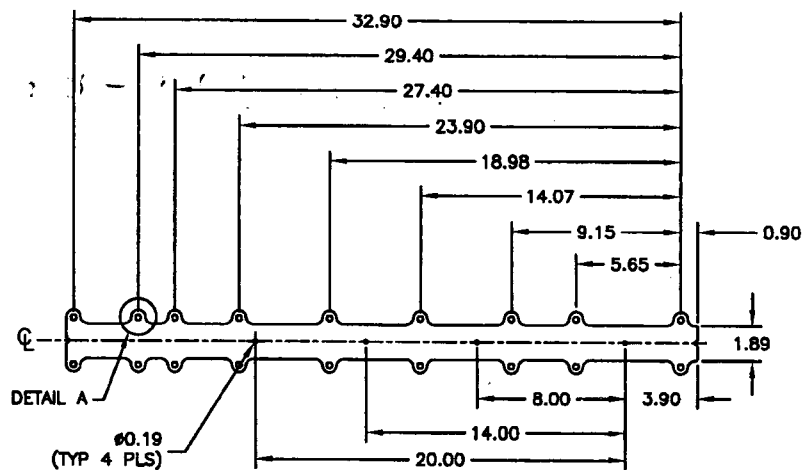
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09.02.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66823



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 1 OF 6	SCALE 1:10
A	06.10.25	NEW ISSUE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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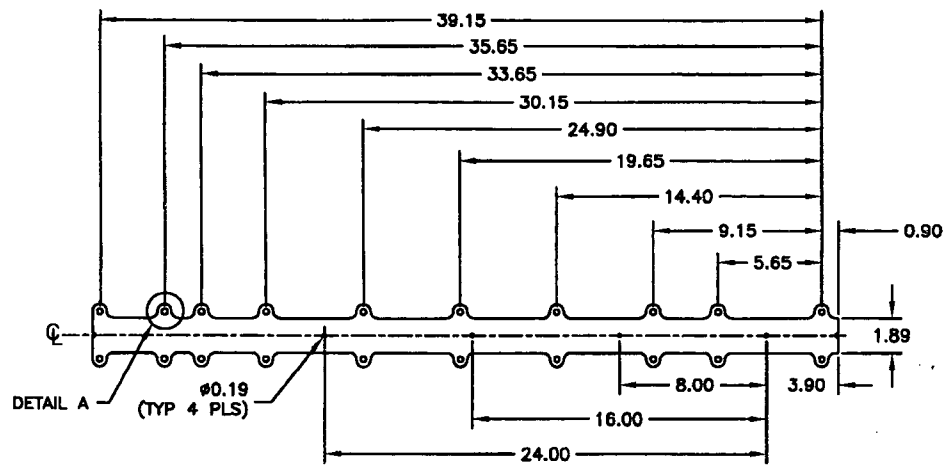
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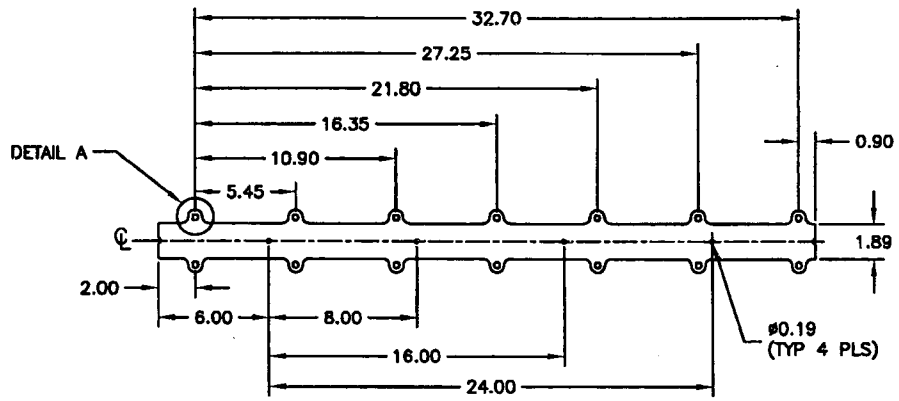
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 2 OF 6
		SCALE	1:10	

RELEASED
07.02.12

46823



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

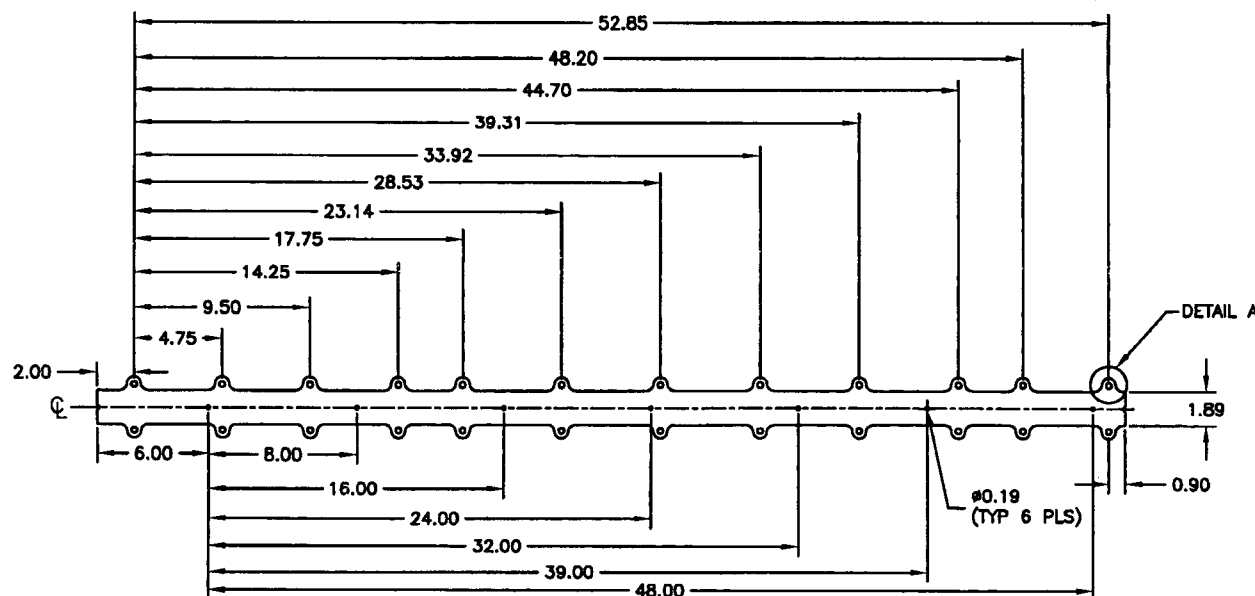
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DART

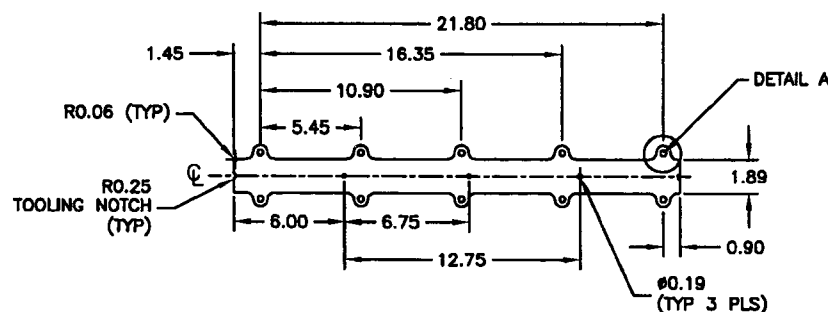
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CB	CB	PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO.	REV. A
DATE 06.10.25		D3536	SHEET 3 OF 6
TITLE GASKET		SCALE 1:10	

RELEASED
07.02.12



D3536-23 GASKET

WLB 66823



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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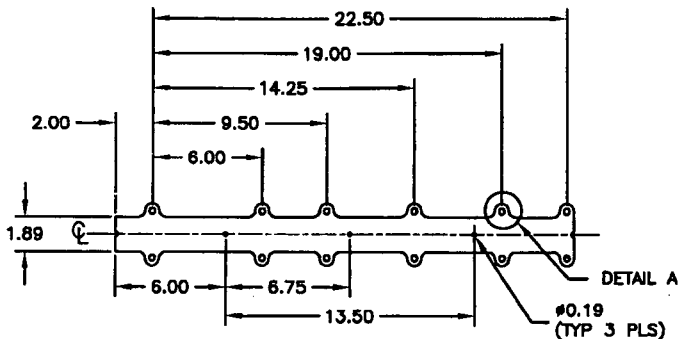
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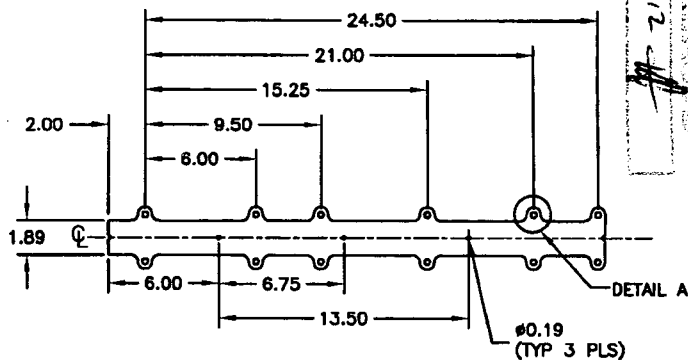
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3536	REV. A SHEET 4 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10

02.02.12

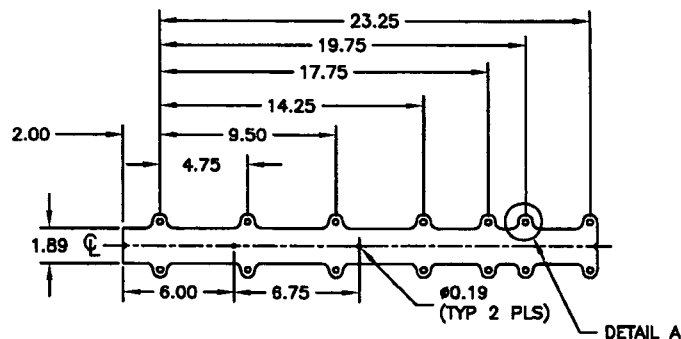


D3536-31 GASKET



D3536-33 GASKET

who 46823



D3536-35 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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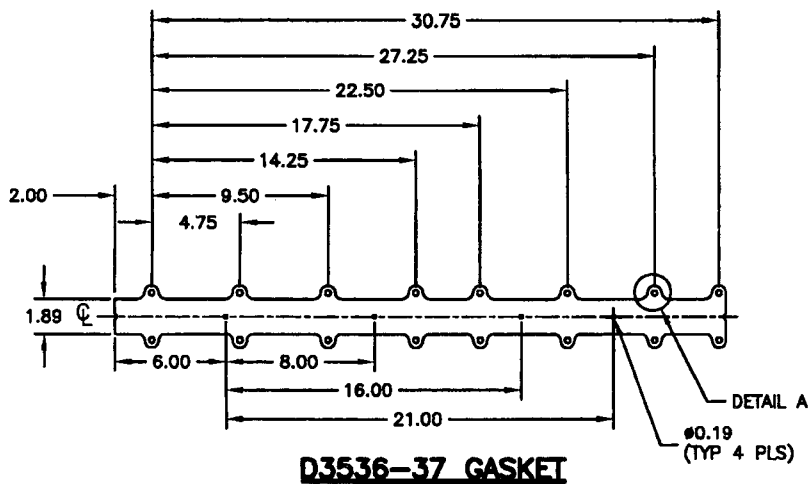
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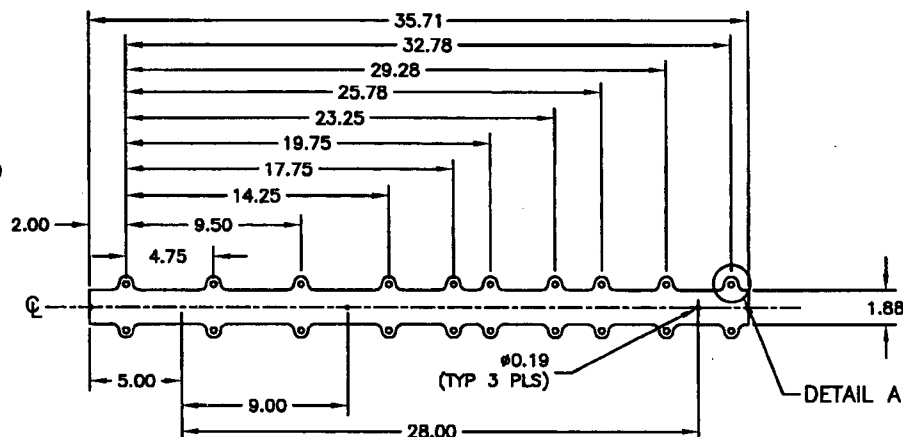
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 5 OF 6
				SCALE
				1:10

07.02.12
07.02.12
07.02.12

u/b 66823



D3536-37 GASKET



D3536-39 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 80 DUROMETER (REF DART SPEC. M-NE080-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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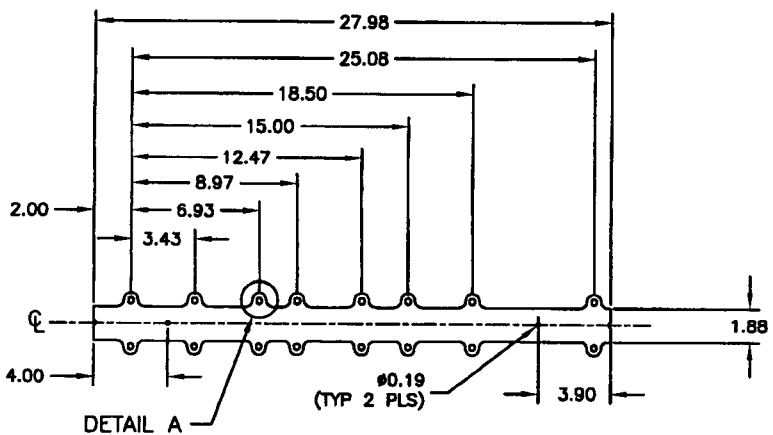
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DART

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DATE 06.10.25	TITLE GASKET	SHEET 6 OF 6	SCALE 1:10

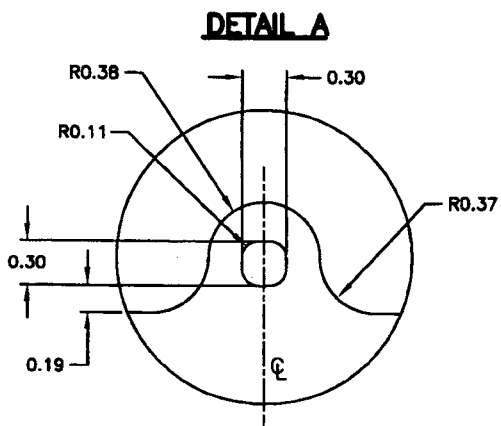
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D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
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